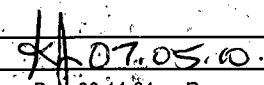


Date: Thursday, 5/10/2007 2:25:50 PM  
 User: Kim Johnston

## Process Sheet

Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name:	ARM
Job Number:	32284	Part Number:	D28441
Estimate Number:	11047	Drawing Number:	D2844 REV A
P.O. Number:	N/A	Project Number:	N/A
This Issue:	5/10/2007	Drawing Revision:	A
Prsht Rev:	NC	Material:	N/A
First Issue:	N/A	Due Date:	5/30/2007
Previous Run:	29785	Qty:	20
Written By:		Um:	Each
Checked & Approved By:			
Comment:	Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	M304TRO500W035	304 RD Tube .500 x .035W
-----	----------------	--------------------------



Comment: Qty: 1.9941 f(s)/Unit Total: 39.8811 f(s)  
 304 RD Tube .500 x .035W  
 M304TRO500W035  
 Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 21.49" long (Hole ctr. to hole ctr.) using  
 Jig DT 8012

Batch

17103987 x 2 / m104489 x 18

FF 07-05-24 20

2.0	*BRAKE NC	NC BRAKE
-----	-----------	----------



Comment: BAND SAW  
 Form per Dwg D2844 using brake and bending Jig DT 8238-B  
 Deburr

FF 07-05-24 20  
 07/05/31 (20)

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/05 (20)

4.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING  
 Powder Coat White, Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

FL 07/06/11 (20)

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/06/11 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/06/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:25:50 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32284

Part Number: D28441

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*CP 07/06/12 (20)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*(20)*

Comment: FINAL INSPECTION/W/O RELEASE

*07/06/10*

Job Completion



*U 07/06/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

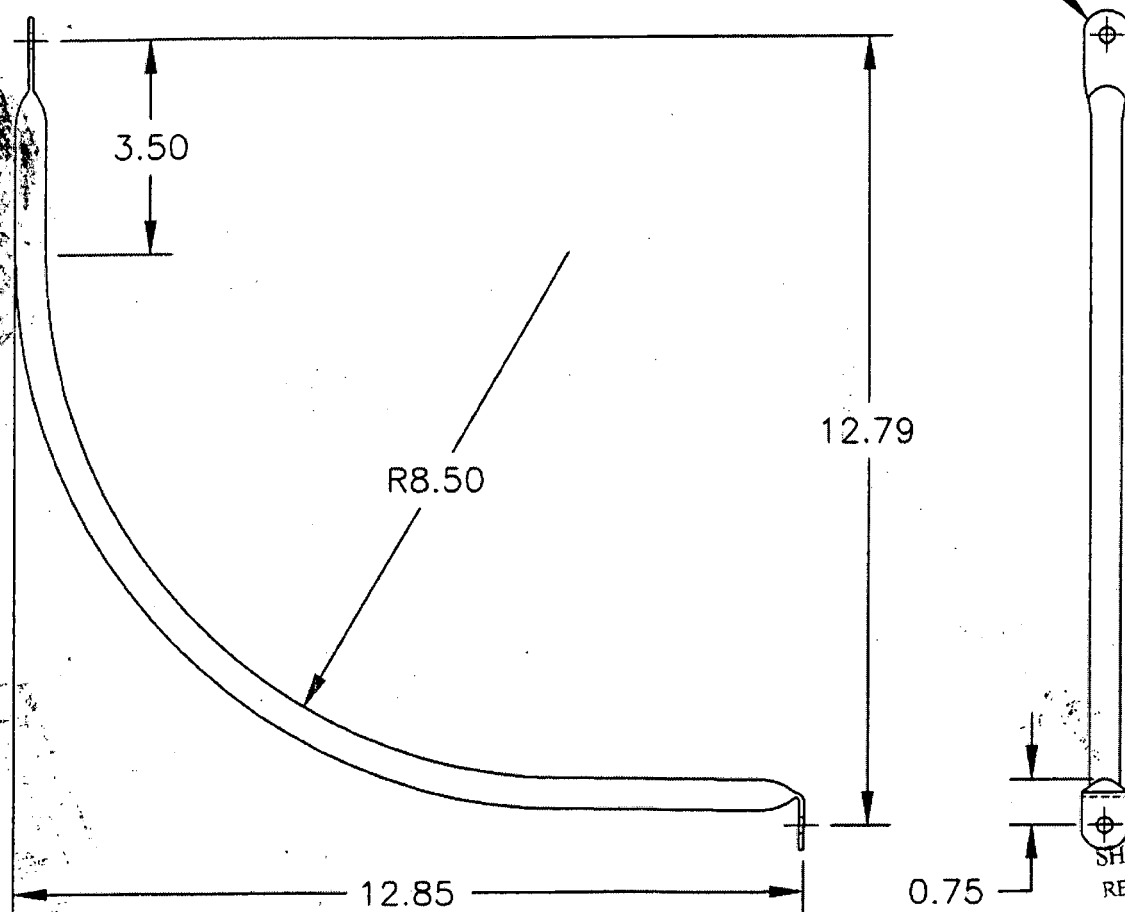
**NOTE:** Date & initial all entries

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>CS</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

**RELEASED**  
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727

D2844-1MATERIAL: AISI 304/316 SS TUBE,  $\phi 0.50 \times 0.035$  WALL

ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

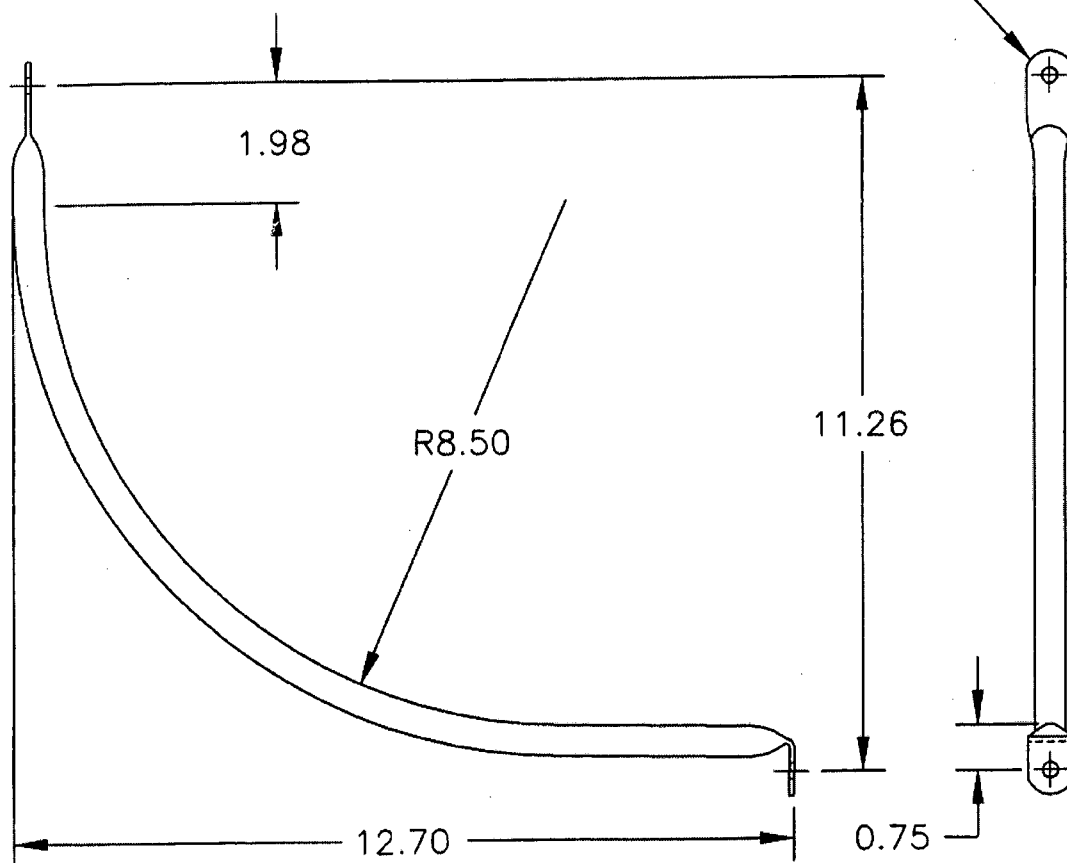
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32284



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3

RELEASED  
18.11.11 *KE*

PUNCH ENDS PER SPEC CONTROL DRAWING D2727

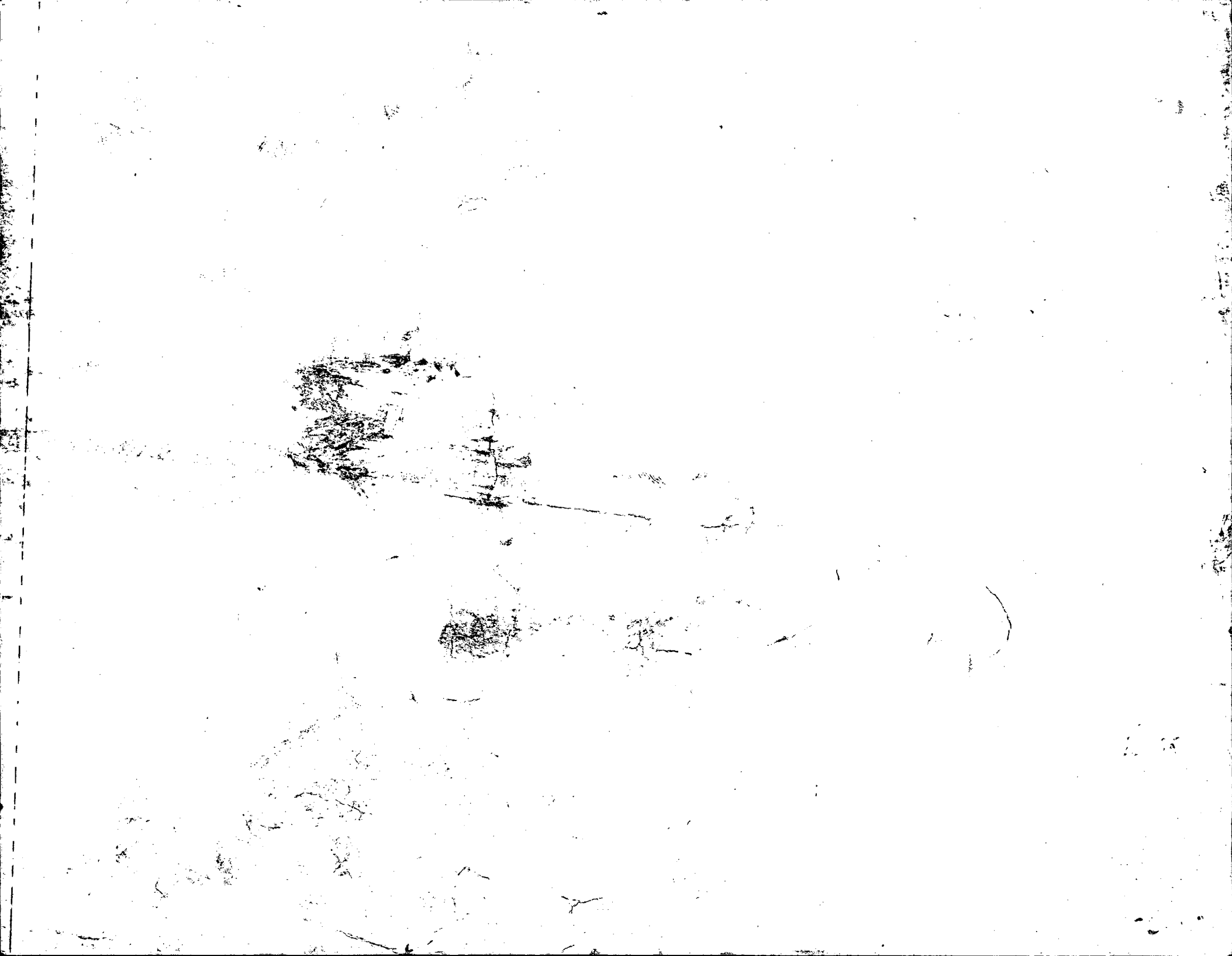


D2844-3

MATERIAL: AISI 304/316 SS TUBE,  $\phi 0.50 \times 0.035$  WALL  
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32284



Date: Thursday, 21/06/2007 9:57:52 AM  
User: Linda Lacelle

# Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D2844-1/3
Job Number	: 33029		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: D28441
This Issue	: 21/06/2007 S.O. No. : N/A	Drawing Number	: REWORK
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : R&D GENERAL	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	:	Due Date	: 28/06/2007
Checked & Approved By	:	Qty:	32 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL &amp; MEDIUM FAB RESOURCE 1</p> <p>REMOVE FROM STK:</p> <p>4 D2844-1 B 32284 (13) / B 29785 (11) FF 07-06-21 32</p> <p>1 D2844-3 B 14087 x 2 SAN 07-06-21 32</p>		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL &amp; MEDIUM FAB RESOURCE 1</p> <p>REWORK PER NCR 172</p> <p>PER DRWG D2844 REV.A</p> <p>SAD 07-06-21 32</p> <p>SB 07-06-21 (72)</p>		
3.0	QC5	INSPECT WORK TO CURRENT STEP
<p>Comment: INSPECT WORK TO CURRENT STEP</p> <p>07-06-25 D2844-3 (2) (PTO)</p> <p>D2844-1</p>		
4.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1</p> <p>ID &amp; STK</p> <p>USING SAME BV/N</p> <p>(9) B 32284 07/6/26</p> <p>(2) B 14087</p> <p>(8) B 29785</p>		